

Work Order ID 61363

Thursday, August 19, 2010 1:56:39 PM



Page 1

Item ID:	D3281-1L08	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Floor Protector, Fwd LH					
Start Date:	8/19/2010	Start Qty: 3.00		Cust Item ID:		
Required Date:	8/25/2010	Req'd Qty: 3.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>unt</u>	Date:	<u>08-19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3281	DEO E-1

100		0.00							
	HAND FINISHING THERMOFORMING								<u>OK (13) 10/08/24</u>
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								

105		0.00							
	Dry Material								<u>OK 10/08/25</u>
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 240° F

Time IN: 5:00 pm 10/08/24 OK

Time OUT: 7:00 am 10/08/25 OK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Thermoform	THERMOFORMING MACHINE	0.00							
Thermoforming Machine	Memo Thermoform as per Dwg. D3281 and Folio FTA 011 Dwg. Rev. <u>E</u> Folio Rev. <u>D</u>	0.00							<u>10/08/25</u>
120  QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00							<u>10/08/25</u>
130  Thermoform	HAND FINISHING THERMOFORMING	0.00							
Thermoforming Machine	Memo Trim to Finished Dimensions	0.00							<u>10/08/25</u>

Dart Aerospace Ltd

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Item ID: D3281-1L08

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Fwd LH

Start Date: 8/19/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

H23 10/08/25

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/08/30

+3

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

PP 6362

10/8/31 (3) SP

W/O:		WORK ORDER CHANGES					
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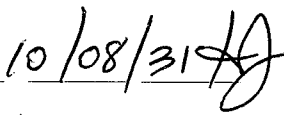


Page 4

Item ID: D3281-1L08 Accept  Setup Start 
Revision ID:
Item Name: Floor Protector, Fwd LH Stop 
Start Date: 8/19/2010 Start Qty: 3.00  Cust Item ID:
Required Date: 8/25/2010 Req'd Qty: 3.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/08/31 
C21018131

Dart Aerospace Ltd

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Picklist Print

Thursday, August 19, 2010 1:56:38 PM

Page 1

Work Order ID: 61363

Parent Item: D3281-1L08

Parent Item Name: Floor Protector, Fwd LH

Start Date: 8/19/2010



Required Date: 8/25/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev A 10.02.24 New Issue LL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 		Purchased	No			100	sf	2,563.470	5	15.78947			
Lexan Sheet													

Location

therm

Loc Qty

2563.47

2563.47

Loc Code

113127

15 sq ft. Dr. 10/08/25

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	
Description: Floor Protector, Fwd LH		Part Number:	D3281-1
Inspection Dwg: D3281	Rev: <i>DE DL</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

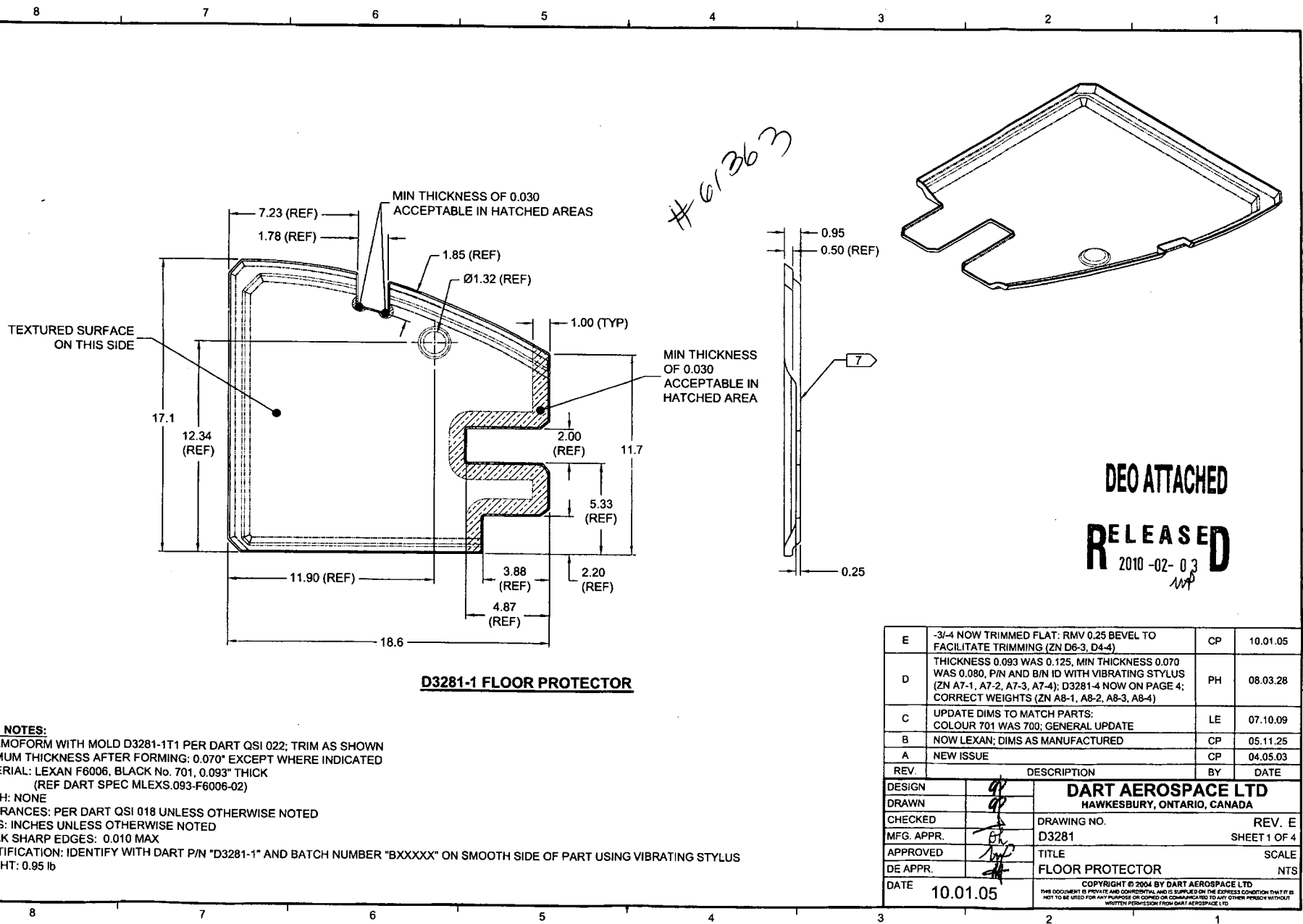
Measured by: <i>DL</i>	Date: <i>10/08/25</i>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	<i>18.5"</i>	✓			
17.1	+/-0.100	<i>17.065"</i>	✓			
11.7	+/-0.100	<i>11.625"</i>	✓			
0.95	+/-0.030	<i>0.971"</i>	✓			
0.25	+/-0.030	<i>0.26"</i>	✓			
0.030	Min	<i>0.047"</i>	✓			
0.070	Min	<i>0.080"</i>	✓			

Measured by: <i>DL</i>	Date: <i>10/08/25</i>
Audited by: <i>JB</i>	Date: <i>10/08/25 27</i>
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	



E	-3/-4 NOW TRIMMED FLAT; RMV 0.25 BEVEL TO FACILITATE TRIMMING (ZN D6-3, D4-4)	CP	10.01.05
D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	9/	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3281 TITLE FLOOR PROTECTOR SCALE NTS DATE 10.01.05	
DRAWN	9/		
CHECKED	9/		
MFG. APPR.	9/		
APPROVED	9/		
DE APPR.	9/	REV. E SHEET 1 OF 4 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Dart Aerospace Ltd

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• **NOTE:** Date & initial all entries

• H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>90</i>	CHECKED <i>JK</i>	MFG. APPR. <i>JK</i>	APPROVED <i>JK</i>	DE APPR. <i>JK</i>		
DATE 10.02.24	DATE 10.02.25	DATE 10/02/25	DATE 10.02.25	DATE 10.02.25		

PURPOSE

ADD "D3281-xL08" MATERIAL OPTION. EXISTING PARTS TO BE IDENTIFIED AS "D3281-xL02"

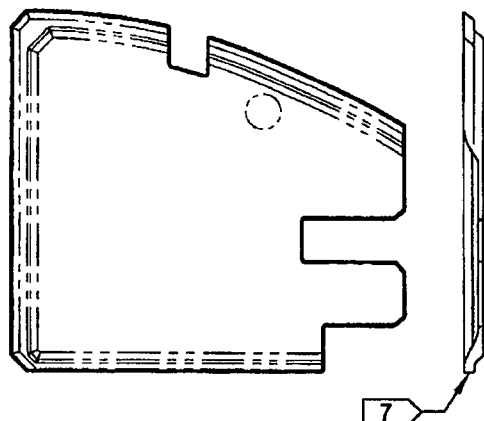
CHANGE

D3281-xL08 PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS EXCEPT AS DETAIL BELOW. THE MATERIAL, IDENTIFICATION, AND WEIGHT NOTES ARE AMENDED AS FOLLOWS:

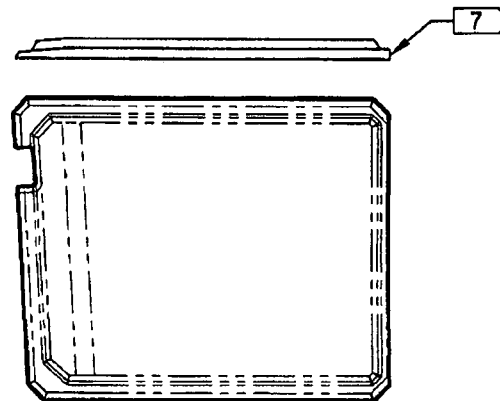
- 2) MATERIAL: -xL02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-xL08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)

- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xLxx" AND B/N "Bxxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.
FOR -xL08 PARTS, LOCATE ENGRAVING ALONG PERIMETER OF PART AS SHOWN.

- 8) WEIGHT: D3281-1L02/-2L02 = 0.95 lb D3281-1L08/-2L08 = 1.13 lb
D3281-1L02/-2L02 = 0.87 lb D3281-3L08/-4L08 = 1.05 lb



D3281-1L08 FLOOR PROTECTOR (SHOWN)
D3281-2L08 FLOOR PRETECTOR (OPPOSITE)
LOCATION OF ENGRAVING



D3281-3L08 FLOOR PROTECTOR (SHOWN)
D3281-4L08 FLOOR PRETECTOR (OPPOSITE)
LOCATION OF ENGRAVING

61363

RELEASED
2010-02-26
MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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